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D2665-2
Job Sheet 196627



Part No: D2665-2

Job Qty: 4 pcs

Part Name: Saddle, RH, Fwd, Aft, Out



Part Weight: 0 lbs

Job Created: 6/17/19

Due Date: 7/12/19

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Lead Time	Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier		
100	HAAS 4 Axis	4 pcs	7/12/19		1.00 8.64	HAAS - 1		536 19/6/16
						HAAS - 2		
						HAAS - 3		
						HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	7/12/19		0.00 0.43	Conventional Mill - 1 - B4B		VHS 19/7/15
						Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	7/12/19		0.00 0.00	QC 2 - 1		
						QC 2 - 12		
						QC 2 - 14		
						QC 2 - 17		
						QC 2 - 19		
						QC 2 - 2		
						QC 2 - 20		
						QC 2 - 22		
						QC 2 - 23		
						QC 2 - 25		
						QC 2 - 32		
						QC 2 - 33		
QC 2 - 35								
QC 2 - 39								
QC 2 - 4								
QC 2 - 40								
QC 2 - 44								
QC 2 - 45								
QC 2 - 48								
QC 2 - 49								
QC 2 - 50								
QC 2 - 51								
QC 2 - 52								

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NCR: 19-7293

				QC 2 - 57					
				QC 2 - 62					
				QC 2 - 63					
				QC 2 - 8					
				QC 2 - 66					
				QC 2 - 64					
				QC 2 - 65					
				QC 2 - 5					
				QC 2 - 71					
				QC 2 - 73					
				QC 2 - 69					
130 QC 8	4 pcs	7/12/19	0.00 0.00	QC 8 - 12					
				QC 8 - 14					
				QC 8 - 17					
				QC 8 - 20	19-07-05				
				QC 8 - 25					
				QC 8 - 3					
				QC 8 - 32					
				QC 8 - 33					
				QC 8 - 35					
				QC 8 - 39					
				QC 8 - 4					
				QC 8 - 44					
				QC 8 - 45					
				QC 8 - 49					
				QC 8 - 58					
				QC 8 - 8					
				QC 8 - 9					
				QC 8 - 68					
				QC 8 - 67					
				QC 8 - 1 (A)					
				QC 8 - 47					
				QC 8 - 40					
				QC 8 - 52					
				QC 8 - 23					
				QC 8 - 57					
				140 Handfinish - 1-1 Chemical-B4B	4 pcs	7/12/19	0.00 0.31	Handfinish - 1 - 1 - B4B	8EB19/07/08
								Handfinish - 1 - 2 - B4B	
Handfinish - 1 - 3 - B4B									
Handfinish - 1 - 4 - B4B									
Handfinish - 1 - 5 - B4B									
Handfinish - 1 - 6 - B4B									
Handfinish - 1 - 7 - B4B									
Handfinish - 1 - 8 - B4B									
Handfinish - 1 - 9 - B4B									
Handfinish - 1 - 10 - B4B									
Handfinish - 1 - 11 - B4B									
Handfinish - 1 - 12 - B4B									
Handfinish - 1 - 13 - B4B									
Handfinish - 1 - 14 - B4B									
Handfinish - 1 - 15 - B4B									
Handfinish - 1 - 16 - B4B									
Handfinish - 1 - 17 - B4B									
Handfinish - 1 - 18 - B4B									
Handfinish - 1 - 19 - B4B									
Handfinish - 1 - 20 - B4B									
Handfinish - 1 - 21 - B4B									
Handfinish - 1 - 22 - B4B									
150 Powdercoat - 1 White GI(A)-	4	7/12/19	0.00 0.18					Powdercoat - 1 - B4B	
				Plex 6/17/19 2:46 PM Dart.lajeunesse.marie					

B4B		pcs			Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	3219-78
160 QC 3	7/12/19	0.00 0.00	pcs	1	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
170 Packaging 3-1 - Stock - B4B	7/12/19	0.00 0.00	4 pcs		QC 3 - 24	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	→ 0.2 Bpn: ST402 ✓
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	

6/17/2019 [Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

180 QC 21 - SA	4 pcs	7/12/19	0.00 0.00	Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - HAAS CNC Vertical Machine - 1- Program batch number 2- Machine Step # 1 of Folio and visually inspect as per Descriptions: attached Dimension Sheet 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet 4- Machine Step # 3 of Folio and visually inspect as per attached 110 - Manufacture as per dwg Machine Keyway and inspect per attached dimension sheet 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: OVEN TEMPERATURE: FINISH TIME: 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: 180 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6101-003	Saddle Billet, 7075	4 pcs (1 ea)	100-HAAS 4 Axis	S156 345	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	D6101-003	4	52	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order:	196627
Description: 206 Saddle, Outboard, Right side		Part Number:	D2665-2
Inspection Dwg: D2665	Rev: D	DSK:	Rev:
			Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.111	0.117	0.112	0.112	
B	0.100	0.140		0.123	0.117	0.117	0.118	
C	1.125	1.145		1.135	1.185	1.185	1.135	
D	0.615	0.685		0.665	0.665	0.665	0.669	
E	0.240	0.260		0.252	0.245	0.246	0.250	
F	1.313	1.343		1.325	1.323	1.323	1.323	
G	0.210	0.230		0.223	0.221	0.215	0.220	
H	0.100	0.180		0.128	0.128	0.128	0.128	
I	2.470	2.510		2.499	2.499	2.499	2.499	
J	1.565	1.585		1.575	1.575	1.575	1.575	
K	0.235	0.240		0.238	0.2375	0.2375	0.238	
L	0.100	0.120		0.113	0.114	0.1135	0.114	
M	0.990	1.010		1.001	1.007	1.005	1.0085	
N	0.510	0.515		0.510	0.510	0.510	0.510	
O	5.990	6.010		5.995	5.995	5.994	5.993	
P	1.245	1.255		1.249	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.312	0.318		0.312	0.312	0.312	0.312	
S	0.315	0.322		0.315	0.316	0.316	0.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	
U	1.357	1.367		1.363	1.363	1.363	1.363	
V	0.787	0.807		0.792	0.792	0.792	0.792	
W	0.540	0.560		0.545	0.544	0.544	0.544	
X	1.674	1.684		1.679	1.679	1.679	1.679	
Y	0.256	0.262		0.257	0.257	0.257	0.257	
Z	0.912	0.932		0.916	0.916	0.916	0.916	
AA	0.490	0.510		0.501	0.502	0.500	0.500	
AB	0.178	0.198		0.188	0.186	0.188	0.188	
AC								
AD								
AE								
Accept/Reject					Scrap	Scrap	Scrap	

Measured by:	WJ	Date:	19/7/14
Audited by:	JS	Date:	19-07-05
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☐ Skid-tube ☐ Machining ☐ Large Fab ☐				Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)							
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY							
				Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Completed By				Lead hand / Supervisor				QC / QA Coordinator			

DQA: 19-07-05

July 9, 2019



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Work Order update only

Work Order: 196 627		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. 02605-2		Rework ☒ Scrap ☒ Use-as-is ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐							
NCR No. 19-7292		Suspected Unapproved		Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐							
Date: 19-07-05		Step #: 100		QTY Effective: 3							
Description Work Order Deviation		Disposition									
Part chattered causing the surface to not be flat. Wall will be too thin if re-machined		Scrap									
Root Cause		FAULT CATEGORY									
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☒ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☒ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☒		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☒ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
MRB (QS1042) Approval INSP 12/9/19/15		Completed By DAS 23		Lead hand / Supervisor Approval Verification A.A 19-07-05		QC / QA Coordinator DAS Approval 55 9-89 19-07-05					